

Work Order ID 61783

Friday, September 03, 2010 10:11:57 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop



Start Date: 9/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-9-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3912	B

100 Pick Kit 0.00



Packaging

Memo

0.00

110 0.00



Small Fab

Memo

0.00

Small Fab 1-Assemble D3912-1/3-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

170



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location SOTSet Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

AK 10/11/22 HF
PL 10-11-19 (6)

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Picklist Print

Page 1

Friday, September 03, 2010 10:12:03 AM

Work Order ID: 61783



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3912-1 		Manufactured	No			100	Each	10.0000	1		6	EJ 10/11/18	
Eyebolt											B63670(4x)		
							<u>Location</u>	<u>Loc Qty</u>					
							FG095	4				2	
							61081	4					
							FG096	6					
							59441	6					
D3912-3 		Manufactured	No			100	Each	6.0000	2		12	EJ 10/11/18	
Eyebolt Block											B61835(10x)		
							<u>Location</u>	<u>Loc Qty</u>					
							ST096	6				2	
							59430	6					
D3912-5 		Manufactured	No			100	Each	7.0000	2		12	EJ 10/11/18	
Eyebolt Plate											B61836(9x)		
							<u>Location</u>	<u>Loc Qty</u>					
							ST096	7				3	
							61078	7					

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Friday, September 03, 2010 10:12:03 AM

Page 2

Work Order ID: 61783



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

D3801-1



Hand Retractable-Spring Plunger

Manufactured No

Each

16.0000

1

6

EJBro/11/19

MS20615-4M20



RIVET

Purchased No

100

Each

266.0000

8

6

EJBro/11/19

MS21209-F615



Heli-Coil

Purchased No

Each

97.0000

1

6

EJBro/11/19

AN960C 6/6

NAS1149F0332P



WASHER

Purchased No

Each

599.0000

1

6

EJBro/11/19

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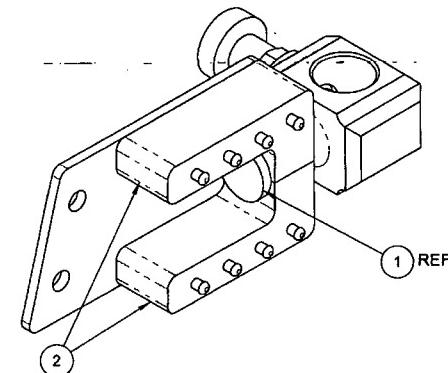
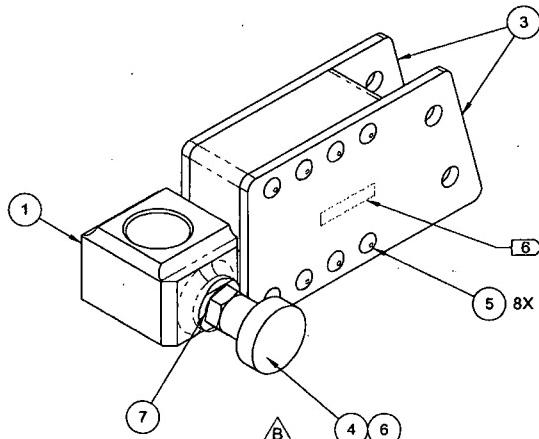
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
X	1	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER

B B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41783
PL 10-9-07

SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

RELEASED
2010-07-16
wp

D3912-041 EYEBOLT RECEIVER ASSY

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.			JPH	10.06.28
A	NEW ISSUE			JPH	10.03.04
REV.	DESCRIPTION	BY	DATE		
DESIGN	<i>115</i>			DART AEROSPACE LTD	
DRAWN	<i>11</i>			HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>11</i>			DRAWING NO.	REV. B
MFG. APPR.	<i>11</i>			D3912	SHEET 1 OF 3
APPROVED	<i>11</i>			TITLE	SCALE
DE APPR.	<i>11</i>			EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
 FINE POINT PERMANENT INK MARKER
 7) WEIGHT -041: 1.58 lbs

8 7 6 5 4 3 2 1

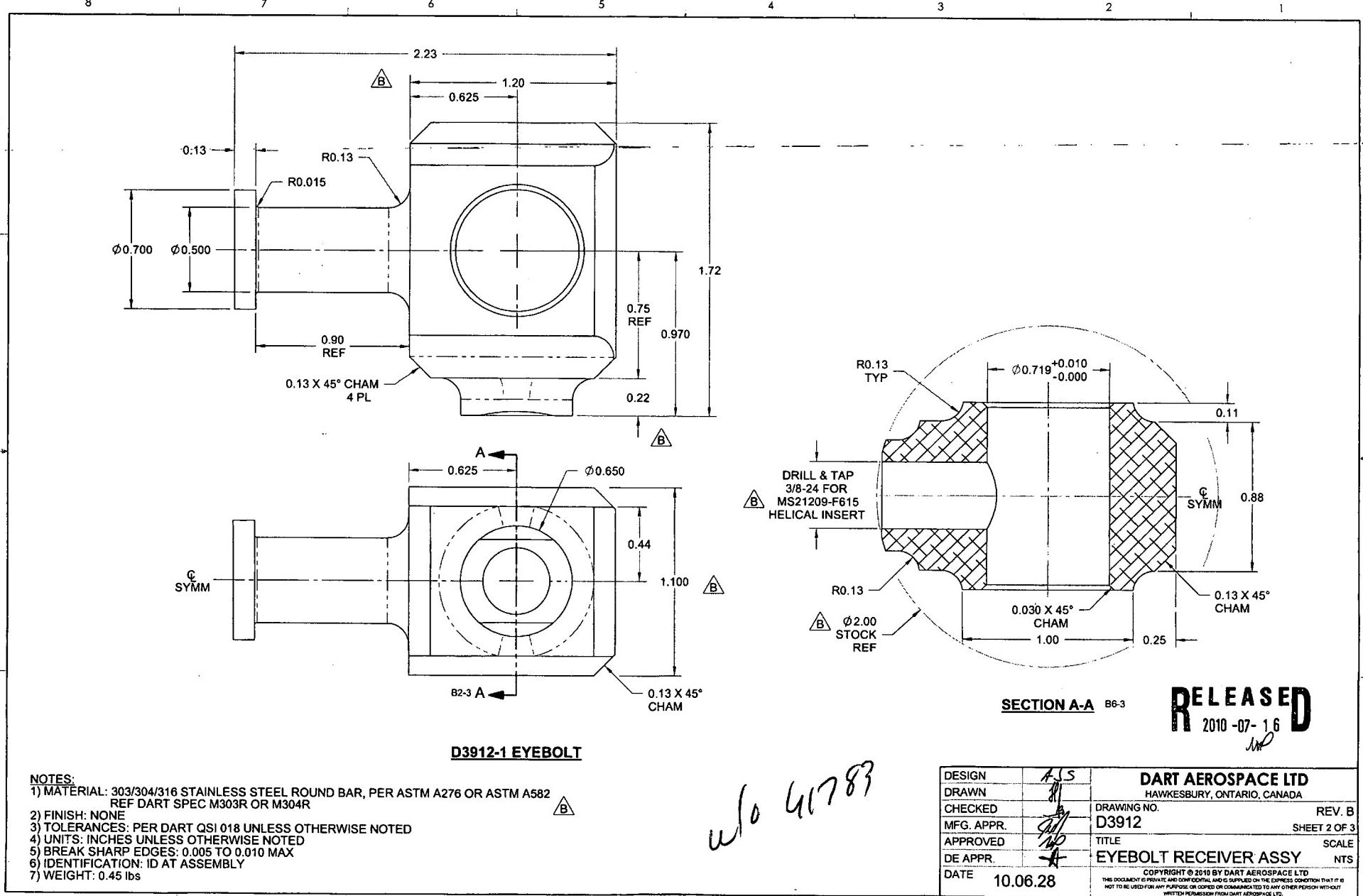
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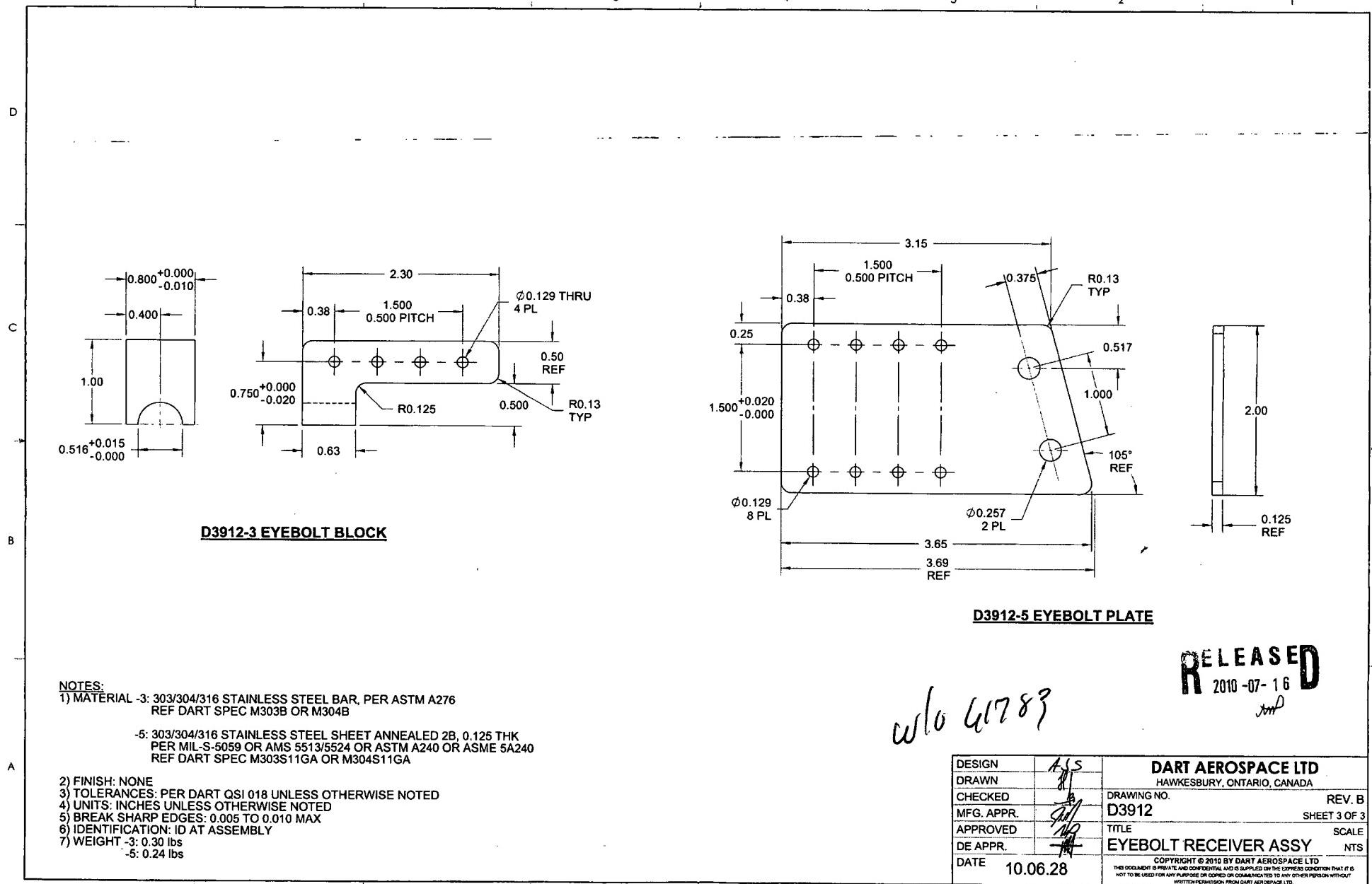
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8 7 6 5 4 3 2 1

**NOTES:**

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
w/6 41789

DESIGN	<i>A/S</i>	DART AEROSPACE LTD	
DRAWN	<i>81</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>B</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SJ</i>	D3912	SHEET 3 OF 3
APPROVED	<i>JW</i>	TITLE	SCALE
DE APPR.	<i>JW</i>	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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